

Work Order ID 73570

Tuesday, September 06, 2011 8:42:31 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/09/08 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

100



DC

Document Control

DOCUMENT CONTROL

3/30

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

Suliz/08

MLJ 11-12-8
(8)

160



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

CL/12/08
(8)

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Suliz/08

(x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 011 □ Location: <u>012 MVA</u>	D350-578-							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

[Signature]

11/12/8 *[Signature]*

MF
11-12-08

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 8:42:27 AM

Page 1

Work Order ID: 73570

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 9/6/2011

Required Date: 9/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A 		Purchased		No		160	Each	695.0000	12	96			
Bolt													

Location Loc Qty Loc Code

ST358	300	
116419	0	
116704	0	
117514	200	
117619	100	
ST359	395	
116704	95	
118628	300	

D2182B 		Manufactured		No		160	f	143.7312	2.5	20			
Rubber Cushion													

Location Loc Qty Loc Code

ST410	143.73117	
66063	143.73117	

6 to
measured
Cut qty 6 at 5.00" long

118628

73932

7/12/11 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, September 06, 2011 8:42:28 AM

Work Order ID: 73570

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 9/6/2011

Required Date: 9/19/2011

Start Qty: 8.00

Required Qty: 8.00

D2274

Manufactured No

160

Each

666.0000

12

96



Radius Block



74435 *Le*

Location

Loc Qty

Loc Code

ST010

253

69736

200

69773

53

ST011

413

72121

413

D2432

Manufactured No

160

Each

0.0000

12

16



206 (24") Bearpaw



B74491 *Le* 11/12/8

D2438

Manufactured No

160

Each

215.0000

6

48



Clamp



73400 *Le*

Location

Loc Qty

Loc Code

ST456

215

68673

17

69737

108

70693

90

D2529

Manufactured No

160

Each

415.0000

12

96



Washer



76086 62x *Le* 11/12/8

Location

Loc Qty

Loc Code

ST016

415

66953

165

71161

250

7116128x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73570

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 9/6/2011

Required Date: 9/19/2011

Start Qty: 8.00

Required Qty: 8.00

MS21042L4

Purchased

No

160

Each

3,813.000

12

96

Nut

Location

Loc Qty

Loc Code

ST300

3813

117441

51

117601

637

117885

1125

118451

2000

NAS1149D0463J

Purchased

No

160

Each

3,591.000

24

192

Washer

Location

Loc Qty

Loc Code

ST298

3591

116025

16

116805

0

117291

1

117460

2

117591

108

118179

67

118384

2397

118612

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

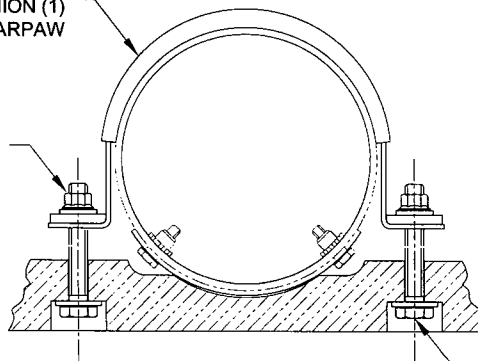
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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REFERENCE ONLY

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F
Date: 08.08.28